

Work Order ID 151303

Tuesday, September 20, 2016 1:42:22 PM

151303

Page 1

Item ID: D3015-1

Revision ID:

Item Name: Lock Nut

Start Date: 9/20/2016 Start Qty: 20.00

Required Date: 10/4/2016 Req'd Qty: 20.00

Reference:

Accept

DAS
13
9-89***N900040100***

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals: Process Plan: DAS 21 9-89 Date: SEP 20 2016

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3015

C

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 33740

Description: SS locknut with nylon insert

Possible Supplier: Acklands P/N: PFSLNNC14S1

Material release note required

50SEP 22 2016DAS
13
9-89

110

0.00

110

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.07

Packaging

Ensure Material Release Note is attached

50x 8016 9-26

120

0.00

120

QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

50DAS
38
9-89
SEP 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 151303***151303***

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Item ID: D3015-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lock Nut
Start Date: 9/20/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 10/4/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STOLS</u>	0.00							
130									
Packaging	Memo	0.03				SD	DAS 6 9-89		SEP 28 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.33					DAS 21 9-89		OCT 03 2016
Quality Control									
							DAS 21 9-89		SEP 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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151303

D3015-1

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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2050
50x 5/16 7-26

SS Locknut

DQA: _____ Date: _____

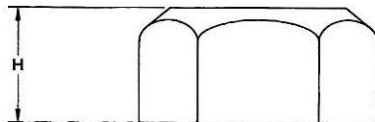
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Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																	
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Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																	
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Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																	
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																	
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																	
		OTHER : _____																																																																		

SPECIFICATION CONTROL DRAWING



D3015-X LOCKNUT

PART NUMBER	SIZE	HEIGHT H	POSSIBLE SUPPLIER
D3015-1	1/4-20 UNC	0.31	ACKLANDS, P/N PFSLNNC14S1
D3015-3	5/16-18 UNC	0.34	ACKLANDS, P/N PFSLNNC516S1
D3015-5	7/16-14 UNC	0.46	ACKLANDS, P/N PFSLNNC716S1
D3015-7	M5	0.19	ACKLANDS, P/N FLMN021-005-0000



NOTES:

- 1) MATERIAL: SS LOCKNUT WITH NYLON INSERT
- 2) FINISH: N/A
- 3) TOLERANCES: ALL DIMENSIONS SHOWN AS REFERENCE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 151303 MJS
 1609-20

RELEASED
 09/07/08

C	REFORMAT DWG. -7 P/N NOW FLMN021-005-0000 WAS LNNM5S1 (ZN B8-1), PAR 09-020	CP	09.07.08
B	ADD D3015-7	KJ	03.07.15
A	NEW ISSUE	DS	01.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.08		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3015** REV. C
 SHEET 1 OF 1
 TITLE **LOCKNUT** SCALE NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33740**

Purchase Order Date 9/22/2016 10:59:31 AM

PO Print Date 9/23/2016

Page Number 1 of 2

Order From :

VC-ACK001

Ship To : DART AEROSPACE LTD

ACKLANDS - GRAINGER INC.
P.O. BOX 2970
WINNIPEG, MB R3C 4B5
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 632 2739

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	PFS-LNNC14S AS PER DWG D3015 REV. C B151303	SS Locknut	9/28/2016 Yes 9/28/2016	FN	50.00 Each	\$0.08	\$3.90
Line Total:							\$3.90
2	5/16-18-015C	SS Bolt 5/16-181.5"	9/28/2016 Yes 9/28/2016	FN	200.00 Each	\$0.23	\$45.52
Line Total:							\$45.52

acklands p/n: FPB U51000.031.0150

Note:

9/23/2016



ACKLANDS-GRAINGER INC.
4475 GRIFFITH

SAINT-LAURENT QC H4T 2A2
(514) 332-6100
www.acklandsgrainger.com

Acklands-Grainger tax ID / N° taxe :
88970-1272/TVQ# 1019602903

Customer tax ID / N° taxe du client:

Contact / Contact:
LAVOIE (613)632-9577

PACKING SLIP / BORDEREAU D'EXPÉDITION

Customer PO / Du client PO:



33740

Sold to / Vendu a: 886364568
DART AEROSPACE LTD:

DART AEROSPACE LTD VMI
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7 CA

Ship to / Adresse d'expédition: 886364568

DART AEROSPACE LTD
DART AEROSPACE LTD VMI
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7 CA

Delivery / Livraison:



6337588662

Shipping conditions /
Conditions d'expédition:
Ship

Incoterms / Incoterms:
Free on board,ORIGIN

Payment terms / Conditions de
paiement:
Net 30 days after invoice date

Account manager / Directeur des
comptes:
350090

Order /
Commande
1272804492

Delivery date / Date d'envoi:
09/22/2016

Order date / Date de la
commande:
09/22/2016

Requisitioner / Demandeur:

Freight terms / Modalités de fret:
Prepaid and Add

Carrier / Transporteur:

Notes / Remarques:

Line / Ligne	PO line / Ligne de BC	Material / Matériau	Customer material / Matériau du client	Description / Description	Ship quantity / Quantité	Order quantity / Quantité commandée	UoM / Unité de mesure	Unit price / Prix unitaire	Per / Par	Extended price / Prix total
000010		FPBU51738.025.0001		LOCKNUT NY RGL SS304 UNC 1/4-20	50.000	50.000	EA	7.80	100	3.90
000020		FPBU51000.031.0150		CAPSCREW SS304 UNC 5/16-18X1-1/2	180.000	200.000	EA	27.76	100	49.97
00:00:00					Freight / Fret					0.00
					Subtotal / Total partiel					53.87
Received by / Recu par:					PST/QST / TVP/TVQ					0.00
					HST/GST / TPS/TVH					7.00
					Order total / Total de la commande					60.87